

Date: Thursday, 9/20/2007 3:26:47 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOOR PROTCTOR RH		
Job Number	34740		Part Number	D32803		
Estimate Number	11225		Drawing Number	D3280 REV B UNDER REVIEW		
P.O. Number	:		Project Number	N/A		
This Issue	9/20/2007	S.O. No. :	Drawing Revision	07.10.24		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : THERMOFORMING	Due Date	9/27/2007	Qty:	5 Um: Each
Previous Run	30769					
Written By	:					
Checked & Approved By	:					
Comment	Est RevA 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	F6002 701	lexan black
Comment: Qty.: 4.3600 sf(s)/Unit Total : 21.8000 sf(s) lexan black .125"		
Material Batch # <u>103935</u> x2 <u>105952</u> x6		PTO.  x 07.10.10 D.L. 07.10.25 D.L.

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks		
		 x6 07.10.10 D.L. 07.10.25 D.L.

3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D32811and Folio FTA 012		
Dwg. Rev. <u>B</u> Folio Rev. <u>B</u>		 x2 07.10.10 D.L. PTO- x6 07.10.10 D.L.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
		 D.L. 07.10.24 D.L. 07.10.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3280 - 3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/11/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.10	3	2 PARTS NOT FORMED. PROPERLY Parts scrap R.C. <del>Temp</del> tempure loss	QS1012	Scrap 2 parts. Scrap / clean and replaced	07/10/25 Liu	✓ 7/10/25	✓ as per.	✓ Ac/15
7/10/10		too quiet 7  2 parts not flat and have a small flat	ie 07/10/25 QS1042	Scrap and N/A			ie 07/10/25 G1072	✓ Ac/15

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:26:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR RH

Job Number: 34740

Part Number: D32803

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



(PTO)

Comment: HAND FINISHING THERMOFORMING

DR. 07.10.24

DL 07.10.25

1) Trim to Finished Dimensions

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DR. 07.10.24

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.09.01/05

8.0 PACKAGING 1

PACKAGING RESOURCE #1



ENGINEERING  
APPROVAL



XO 07/11/01 DR

Comment: PACKAGING RESOURCE #1

LE 07.10.25

9.0 QC21

FINAL INSPECTION/W/O RELEASE



07.11.01 DR

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11.07.11.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3280-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/11/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 34740		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/24	S10	16.0 IS 15.18 12.26 IS 12.06	LE 07.10.24 QSI042	Acceptable	LE 07.10.24	 07/10/24	LE 07.10.24 QSI042	 07/10/24

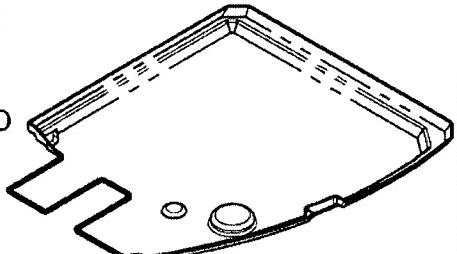
NOTE: Date & initial all entries



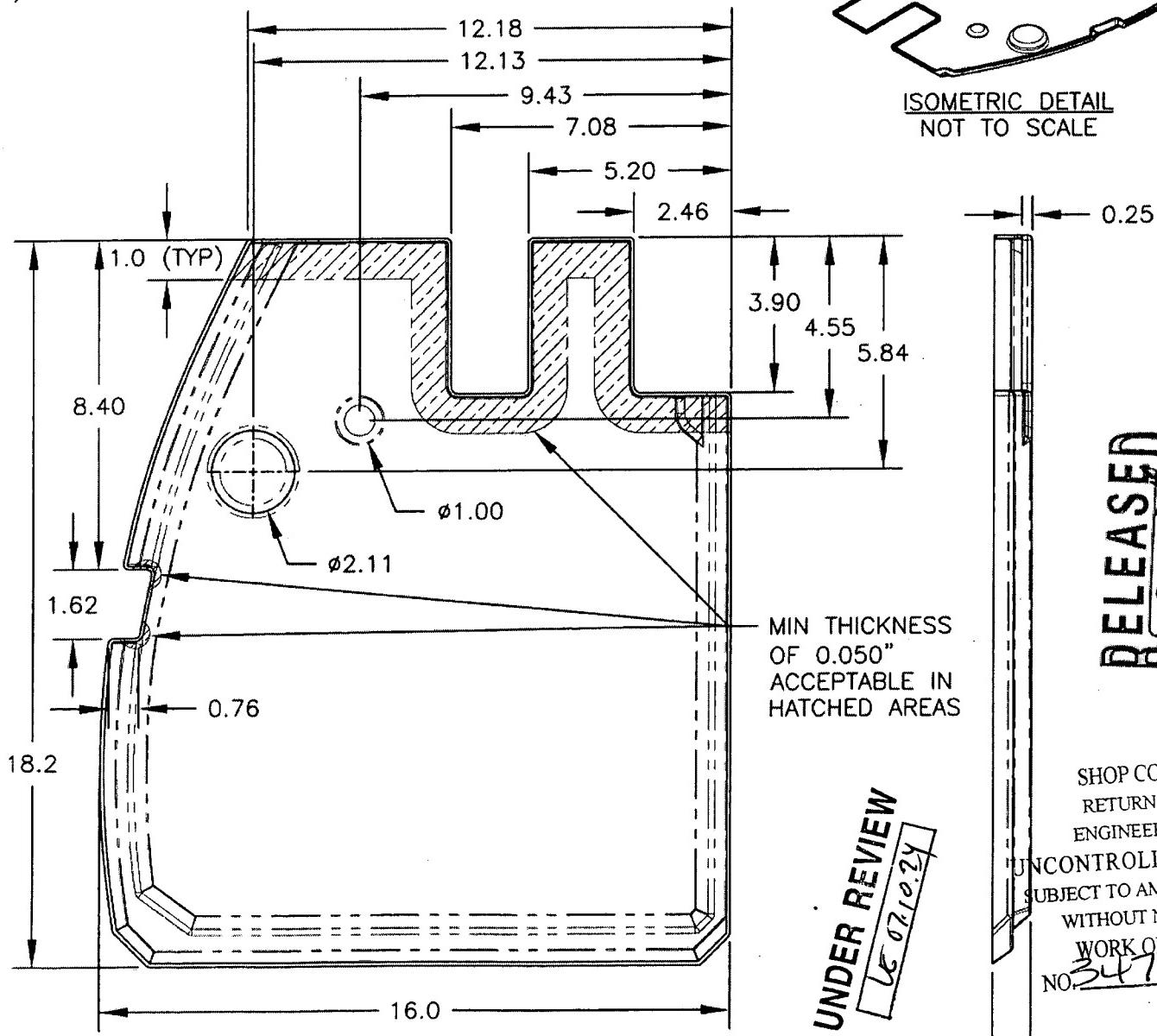
DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D3280	REV. B SHEET 1 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:4
A	04.04.05	NEW ISSUE	
B	05.11.25	NOW LEXAN, DIMS AS MANUFACTURED	

D3280-1 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-1T1, TRIM USING D3280-1T2
  - 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



RELEASED  
05-12-01

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
JECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
34740

UNDER REVIEW  
6-01-024

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

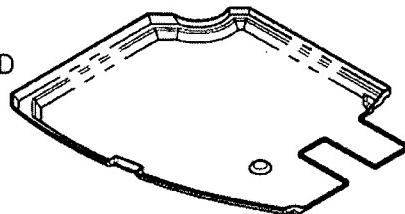


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3280
DATE 05.11.25		TITLE FLOOR PROTECTION

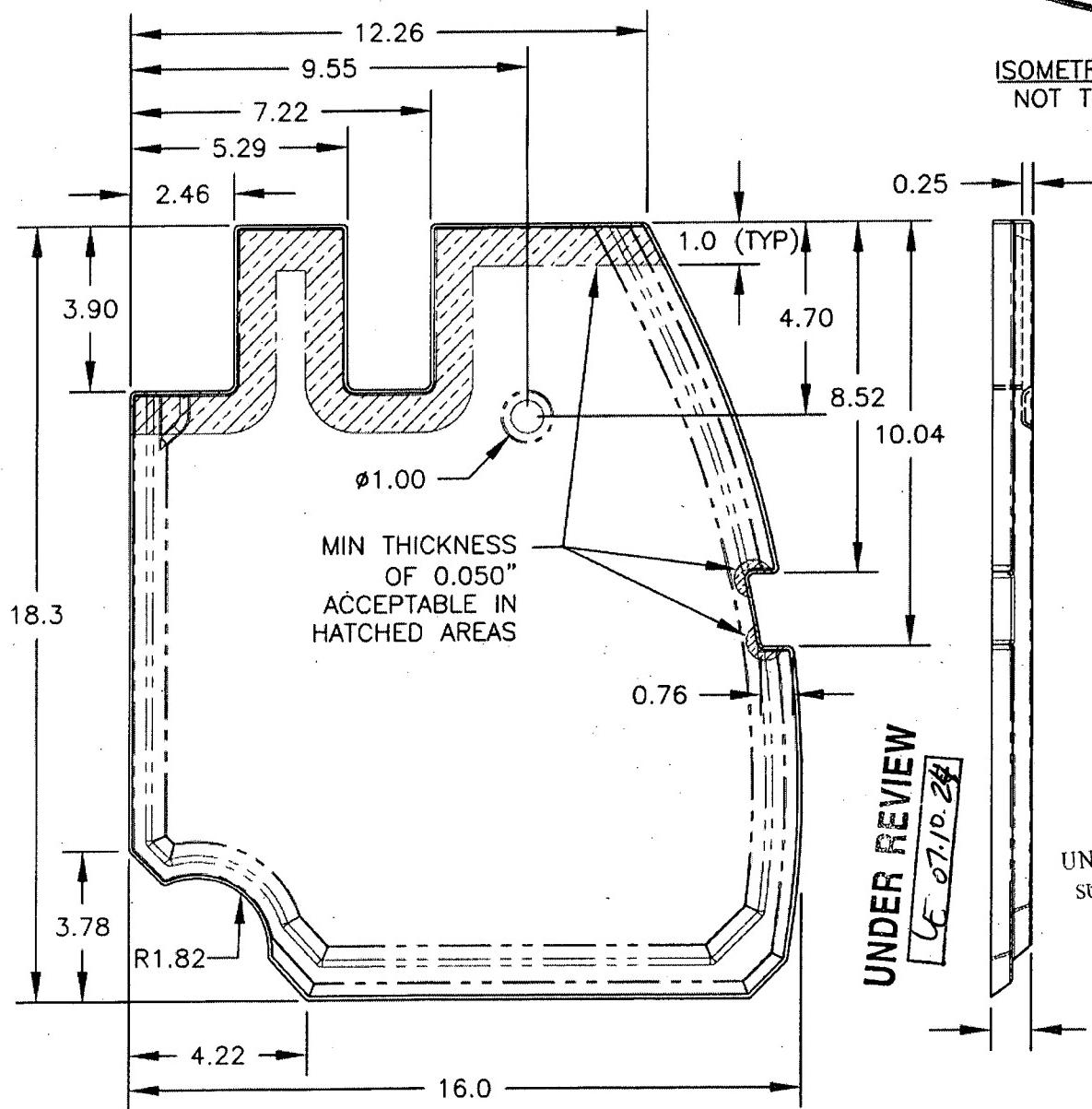
REV. B  
SHEET 2 OF 2  
SCALE  
1:4

### D3280-3 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-3T1, TRIM USING D3280-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080 EXCEPT AS SHOWN



ISOMETRIC DETAIL  
NOT TO SCALE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34740

DART AEROSPACE LTD	WORK ORDER:	34740
Description: R22 Floor Protector RH	Part Number:	D3280-3
Inspection Dwg: D3280 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

First Article  Prototype

## (Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	AF
Acceptable shape definition	MT
Acceptable texture retention	WT
Free of visual flaws (bumps, cracks, voids, etc.)	WT

## (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3280 Rev. B and record below

Measured by:	JL	Audited by:	SR	Prototype Approval:	16
Date:	07.10.24	Date:	07/10/24	Date:	07.10.24

Rev	Date	Change	Revised by	Approved
		New Issue		